

# Work Order ID 54497

December 10, 2009 11:40:02 AM



Page 1

Item ID: D2888

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 15/12/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 24/12/2009 Req'd Qty: 12.00



Customer:

Reference:

*09.12.10*

Approvals:

Process/Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2888

Rev A2

100

0.00



Bandsaw

Jcaspa Bandsaw

Memo

Cut Blanks at 4.200" long  
\*\*\*Grain along 4.200"\*\*\*\*

0.00

*86 09/12/13*

*12 0*

110

0.00



HAAS I

HAAS CNC vertical machine #1

Memo

Machine as per Folio D2888

Folio Rev: *AA*

Dwg Rev: *A2*

2-Deburr

0.00

*86 09/12/13*

*12 0*



**Work Order ID 54497**

December 10, 2009 11:40:03 AM



Page 2

Item ID: D2888

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 15/12/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 24/12/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

CMT 09/12/15

12

8

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Jmf 09.12.16

12

0

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

uma 09/12/17

x12

Hand Finishing



# Work Order ID 54497

December 10, 2009 11:40:03 AM



Page 3

Item ID: D2888

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 15/12/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 24/12/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 11/3/170

Memo

0.00

BL 09-12-17

(12)

Powder Coating

START TIME: 12:00  
OVEN TEMPERATURE: 320°  
FINISH TIME: 12:30

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

7/11 09-12-14

X/12

Quality Control

170

Identify as per dwg & Stock Location: 480

0.00



Packaging

Memo

0.00

9/12/17 (12x) SP

Packaging



**Work Order ID 54497**

December 10, 2009 11:40:03 AM



Page 4

Item ID: D2888

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 15/12/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 24/12/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/18 JG

M/09-12-18

(12)



# Picklist Print

December 10, 2009 11:40:02 AM

Page 1

Work Order ID: 54497

Parent Item: D2888

Parent Item Name: Lug

Comments:

Start Date: 15/12/2009

Required Date: 24/12/2009

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No			100	f	39.4950	4.6800			



6061-T6 Bar 2.50 x 3.50

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

39.495

102838

13.1

110936

1.03

111700

1.365

113403

24

4.6800

SP09/12/13



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	54497
<b>Description:</b> Lug		<b>Part Number:</b>	D2888
<b>Inspection Dwg:</b> D2888 <b>Rev:</b> A2		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

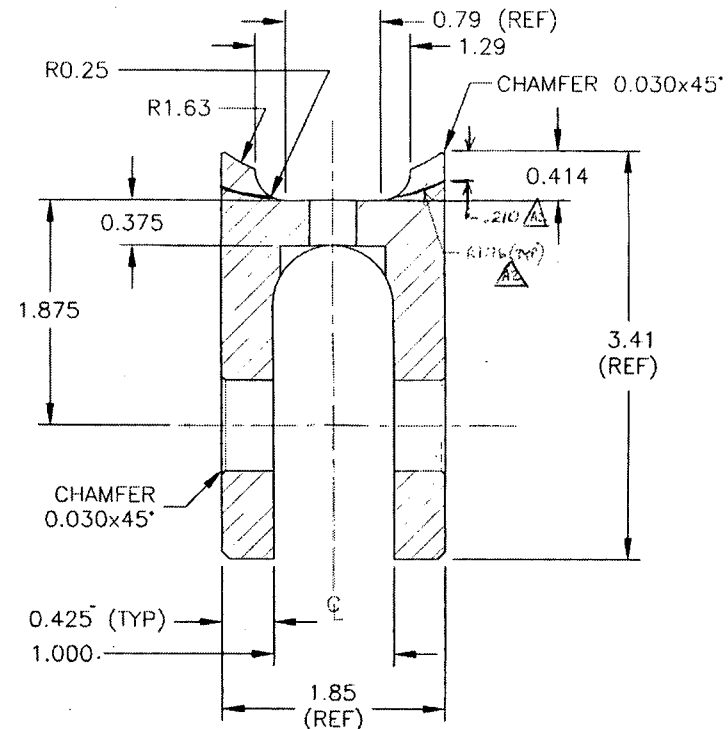
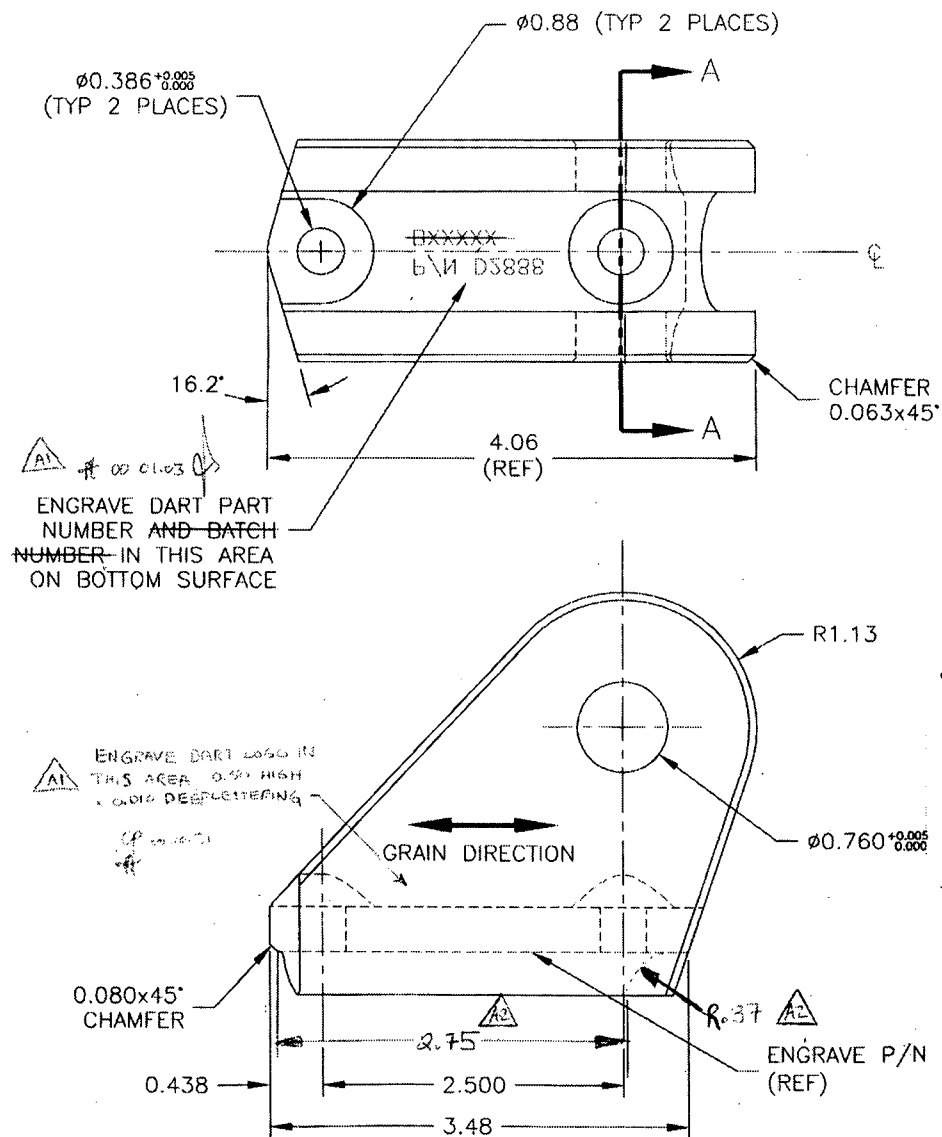
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.386	+0.005/-0.000	.388	✓			
Ø0.88	+/-0.030	.874	✓			
0.063 x 45°	+/-0.010	.063	✓			
4.06	+/-0.030	4.060	✓			
Ø0.760	+0.005/-0.000	.763	✓			
3.48	+/-0.030	3.437	✓			
2.500	+/-0.010	2.497	✓			
<del>2.75</del>	<del>+/-0.030</del>					
0.438	+/-0.010	.435	✓			
0.080 x 45°	+/-0.010	.085	✓			
1.85	+/-0.030	1.850	✓			
1.000	+/-0.010	1.001	✓			
0.425	+/-0.010	.420	✓			
0.030 x 45°	+/-0.010	.030	✓			
1.875	+/-0.010	1.873	✓			
0.375	+/-0.010	.369	✓			
R0.25	+/-0.030	.250	✓			
1.29	+/-0.030	1.282	✓			
0.414	+/-0.010	.409	✓			
3.41	+/-0.030	3.392	✓			

<b>Measured by:</b>	SP	<b>Audited by:</b>	Jul	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	09/12/13	<b>Date:</b>	09.12.16.	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	08.06.04	New Issue	KJ/DD	JD





SECTION A-A  
SCALE 1:1

RELEASED  
99.07.01 DS

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
BREAK UNMARKED EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A2	04.04.08	Add Saddle Clearance for NCR 754
A1	09.10.21	Update Engineering drawing

A	99.06.21	NEW ISSUE
DESIGN	DRAWN BY CP	DART DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2888
DATE	99.06.21	TITLE LUG
		REV. A SHEET 1 OF 1 SCALE 1:1